



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C10-27
Job Sheet 178874



Part No: C10-27

Job Qty: 1 ea

Part Name: Cage Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/8/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C10-27 Rev 9 IPP REV A RQ 17.09.05 VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	1 Ea		6/29/18	0.00	0.00	Start Up Large Fab-1		<i>CL</i>
100	Large Fab	1 pcs		6/29/18	0.00	0.00	Large Fab 3		<i>CL</i>
120	QC	1 pcs		6/29/18	0.00	0.00	QC9		<i>4/20/18-06:12</i>
140	Powdercoat	1 pcs		6/29/18	0.00	0.00	Powdercoat6		<i>BR 18-6-14</i>
160	QC	1 pcs		6/29/18	0.00	0.00	QC3		<i>Sms</i>
180	Packaging	1 pcs		6/29/18	0.00	0.00	Packaging3-1		<i>Sms</i>
200	QC21-SA	1 Ea		6/29/18	0.00	0.00	QC21		<i>21 18-06-14</i>

Part Op 100 - US WELD FIXTURE C-10

Descriptions: 140 - START TIME: *11:25* OVEN TEMPERATURE: *3200* FINISH TIME: *11:55*

17 129223

Job BOM

003786

Part / Item	Component Name	Quantity	Operation	Container
C10-27-1	Lifting Plate	2 Ea (2 ea)	90-Start up Operation	<i>5071484</i>
C10-27-10	Side Loop Wrap Around	2 Ea (2 ea)	90-Start up Operation	<i>5066126</i>
C10-27-2	Cage Reinforcement	2 Ea (2 ea)	90-Start up Operation	<i>5077993</i>
C10-27-3	Front Guard Plate	1 Ea (1 ea)	90-Start up Operation	<i>5070426</i>
C10-27-4-1	Top Ring	2 Ea (2 ea)	90-Start up Operation	<i>5066150</i>
C10-27-8	Bumper Plate	1 Ea (1 ea)	90-Start up Operation	<i>504294</i>
C10-27-9	Space Bar Wrap Around	2 Ea (2 ea)	90-Start up Operation	<i>50067091</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	C10-27-1	2	5	0
	C10-27-10	2	4	0
	C10-27-2	2	10	0
	C10-27-3	1	1	0
	27-4-1	2	4	0
	27-8	1	1	0
	27-9	2	4	0



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S079658



Part: C10-27

Job No: 178874

Serial No/Batch: S079658

Revision: 9

Inspector:

Exp Date:

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

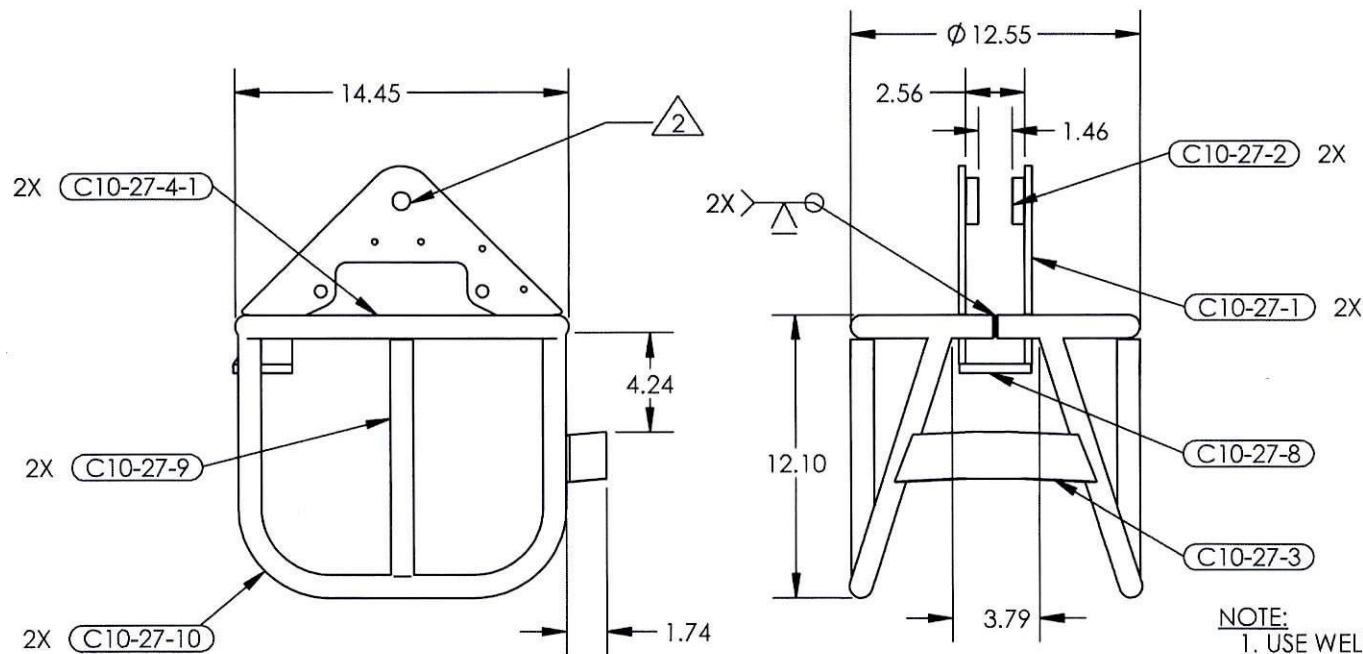
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6		AS DRAWN BY APICAL	1/9/2013	JAG	
7		CH'D 1.27 DIMENSION TO 1.75 TO MATCH PARTS	1/9/2013	JAG	
8		-9 CH'D LENGTH WAS 10 IS 10-1/8. -10 ADDED COPING 2X R .5 X .25 DEEP.	2/27/2013	BIM	JAG
9	16-0169	-9 DELETED FINISH SPEC WAS RAL 3000 IS NO SPEC, CH'D NOTE 1 ADDED C10. ADDED NOTE 2 CH'D DWG TO SHEET METAL TOLERANCE.	10/13/2016	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178874 MJS
180608

- NOTE:
1. USE WELD FIXTURE C-10, WELD ALL CONNECTIONS 100%.
2. HOLES MUST ALIGN.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description
			C10-27-1	2	LIFTING PLATE
			C10-27-2	2	CAGE REINFORCEMENT
			C10-27-3	1	FRONT GUARD PLATE
			C10-27-4-1	2	TOP RING
			C10-27-8	1	BUMPER PLATE
			C10-27-9	2	SPACE BAR WRAP AROUND
			C10-27-10	2	SIDE LOOP WRAP AROUND

DART AEROSPACE	
TITLE CAGE WELDMENT	
DWG NO. C10-27	REV 9
MAT'L FINISH POWDER COAT RED SPEC DRAWN BY: APICAL CHECKED: DUERFELDT OPFS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL	
SCALE 1:8	DATE 9/26/2006 SHEET 1 OF 1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					